

Work Order ID 138693

138693

TULMAP

Page 1

Monday, November 09, 2015 11:03:20 AM

Item ID: PB67-43001-173 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Cover Plate
 Start Date: 11/9/2015 Start Qty: 15.00 *15* Cust Item ID:
 Required Date: 11/27/2015 Req'd Qty: 15.00 *15* Customer:
 Reference:

Approvals: Process Plan: JMF Date: 15-11-9 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
B67-43001-173	D								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.02							
FLOW CNC Waterjet	****Grain direction along 7.19" ****								
	1-Cut as per Dwg B67-43001								
	Dwg Rev: D								
	Prog Rev: D								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

(16)

DC15/11/25

(16)

DC15/11/25

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
		OTHER : ☐							

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Root Cause Environment ☐ No Re-verification ☐ Design ☐ Operator ☐ Doc/Data ☐ Offset/Setup ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
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Page 3

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150									
HandFinish	Memo	0.02							
Hand Finishing									
160	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3	0.00							
160									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 10:35.								
	OVEN TEMPERATURE: 320°								
	FINISH TIME: 11:05.								
170	QC3- Inspect Part Finish	0.00							
170									
QC	Memo	0.00							
Quality Control									

16 15-12-8 DAS 34 9-89

16 15-12-15 DAS 34 9-89

16 15-12-16 DAS 9 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Description Work Order Deviation				Disposition					
				Completed By					
				Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

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138693

Page 5

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	QC6- Inspect dimensions to drawing	0.00							DAS 38 8-89
220									
QC	Memo	0.00							
Quality Control									
230	Identify as per dwg & Stock Location <i>ME222</i>	0.00							
230									
Packaging	Memo	0.00							
Packaging									
240	QC21- Final Inspection - Work Order Release	0.00							
240									
QC	Memo	0.03							
Quality Control									

16

FEB 25 2016

16

DAS
6
8-89

FEB 26 2016

MUS

FEB 26 2016

MUS

FEB 26 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
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				OTHER :							

Picklist Print

Monday, November 09, 2015 11:03:20 AM

Page 1

Work Order ID: 138693

138693

Parent Item: PB67-43001-173

PB67-43001-173

Parent Item Name: Cover Plate

Start Date: 11/9/2015

Required Date: 11/27/2015

Start Qty: 15.00

Required Qty: 15.00

Comments: IPP Rev:A 08-06-20 new issue DD verified by:ec
10.10.04 per revC dwg EC verified by:DD

IPP Rev B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.032		Purchased		No		100	sf	171.5000	1.0548	16.65474			

M2024T3S 032

2024-T3 .032 sheet

Dec 15/16/26

Location

Loc Qty

Loc Code

MAT022

171.5

M130497

8.5

M132875

67

M133452

96

19

DQA: _____ Date: _____



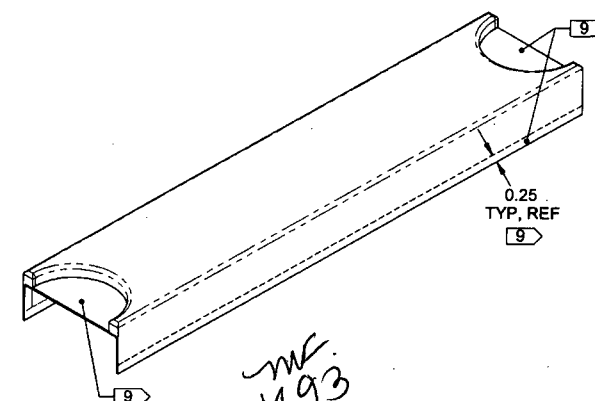
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Skid-tube ☐ Cross tube ☐ Water Jet ☐ Engineering ☐ Scrap ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Quality ☐ Use-as-is ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Suspected Unapproved ☐ Large Fab ☐ Composite ☐ Supplier ☐		AGAINST DEPARTMENT/PROCESS																																																											
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OTHER :																																																															

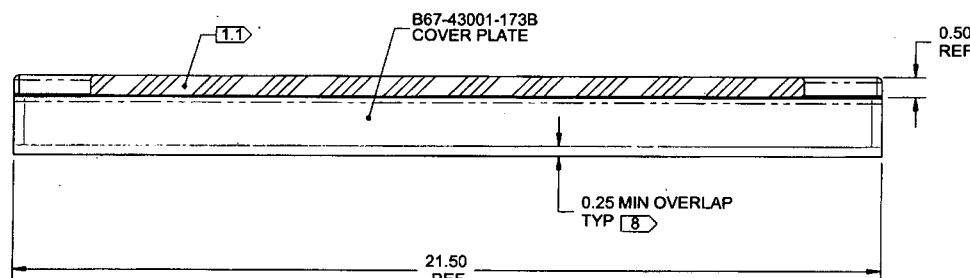
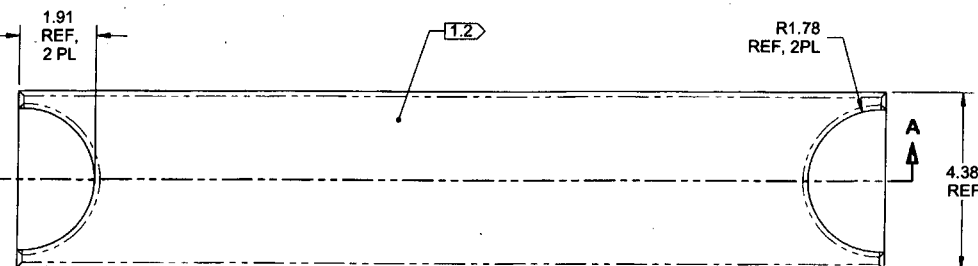
ITEM	QTY	P/N	DESCRIPTION
	X	B67-43001-173	COVER PLATE ASSEMBLY
1	1	B67-43001-173	COVER PLATE
2	A/R	FOAM	SEE NOTE 1.1
3	A/R	FABRIC	SEE NOTE 1.2
4	A/R	ADHESIVE	SEE NOTE 1.3



mc
13893

RELEASED
2014-12-08

B67-43001-173 COVER PLATE ASSEMBLY



SECTION A-A

- NOTES:**
- 1) MATERIAL:
 - 1.1) FOAM: SBR/EPDM/CR BLEND, BLACK, ASTM D1056 2A2, 1/2" THICK, BRITTLNESS TEMP OF -40F, IAW ASTM D 746, FMVSS 302
 - 1.2) FABRIC: 100% 420 DENIER NYLON, MIN THREAD COUNT 35X35, POLYURETHANE COATED ONE SIDE, COLOUR: BLACK REF. TULMAR P/N 1495
 - 1.3) ADHESIVE: URETHANE WITH CATALYST, TWO PART, CLIFTON LA4009 OR LA4009NOVOC
 - 2) FINISH: BOND NEOPRENE TO COVER PLATE USING ADHESIVE. COVER WITH DENIER AS SHOWN.
 - 3) TOLERANCES: PER TABLE 1 (ZN A3-1) UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.78 lbs REF
 - 8) DENIER NYLON TO BE BONDED ALL AROUND INNER SIDES OF PLATE
 - 9) DENIER NYLON TO BE BONDED TO PLATE ON OUTER SIDE

TABLE 1

TOLERANCES ON FABRIC (PARTS AND ASSEMBLIES)
±1/8: DIMS <2
±1/4: DIMS 2 TO <10
±1/2: DIMS 10 TO <20
±5/8: DIMS 20 TO <40
±1.5%: DIMS EQUAL TO OR > 40

D	FOAM AND ADHESIVE SPECS CHANGE TO MATCH SUPPLIER MATERIALS REASON: SEE PAR #14-333	DB	14.07.14
C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018, QSI 043 AND TULMAR SAFETY SYSTEMS INC.'S MANUFACTURING PROCESS AND TOLERANCES ON FABRIC: 4.38 WAS 4.25. FOR PREVIOUS REVISIONS, REFER TO SHEETS 10 AND 27 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.	MB	10.04.27
REV.	DESCRIPTION	BY	DATE
DESIGN	RW		
DRAWN	DB		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.	N/A		
DATE	14.07.14		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. B67-43001-173 TITLE COVER PLATE SCALE NTS REV. D SHEET 1 OF 2 COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

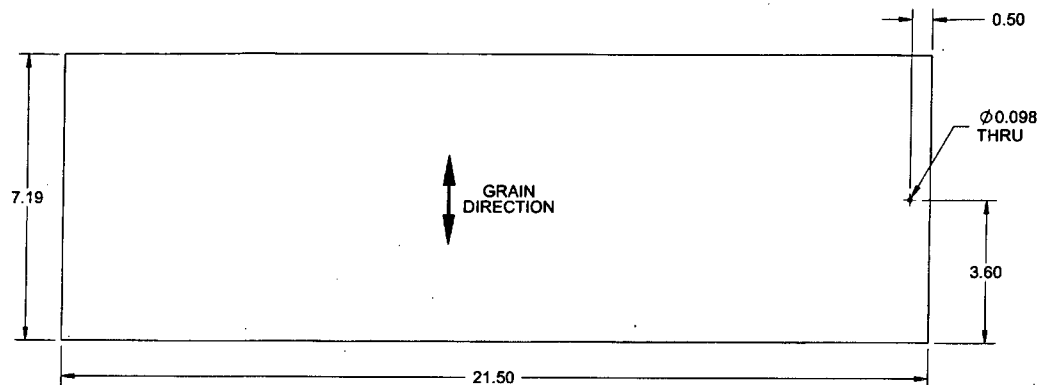
DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

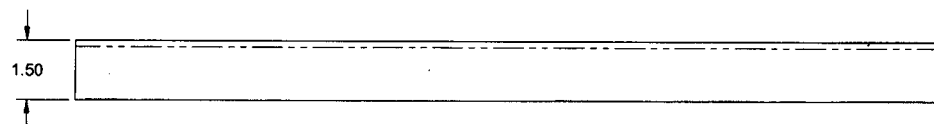
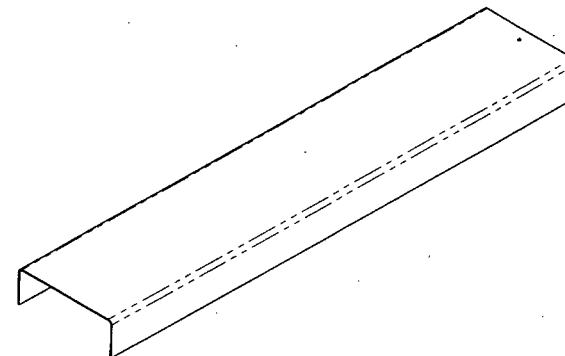
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Work Order update only ☐

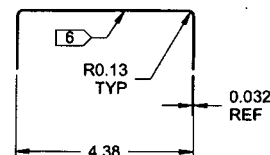
Work Order: _____ Part No. _____ NCR No. _____		Su _____ Date : _____ Step #: _____ Description Work Order De _____		11:42 1:00 06623 <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <th colspan="6" style="text-align: center;">AGAINST DEPARTMENT/PROCESS</th> </tr> <tr> <td>Cross tube</td><td>☐</td> <td>Water Jet</td><td>☐</td> <td>Engineering</td><td>☐</td> </tr> <tr> <td>Small Fab</td><td>☐</td> <td>Prod. Eng. Coord.</td><td>☐</td> <td>Quality</td><td>☐</td> </tr> <tr> <td>Finishing</td><td>☐</td> <td>Rec/Store/Packaging</td><td>☐</td> <td>Other</td><td>☐</td> </tr> <tr> <td>Composite</td><td>☐</td> <td>Supplier</td><td>☐</td> <td></td><td></td> </tr> </table> <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 80%; text-align: center;">Disposition</td> <td style="width: 20%; text-align: center;">MRB (QSI042) Approval</td> </tr> <tr> <td colspan="2" style="height: 100px; vertical-align: top;"> Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval </td> </tr> </table>				AGAINST DEPARTMENT/PROCESS						Cross tube	☐	Water Jet	☐	Engineering	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐	Composite	☐	Supplier	☐			Disposition	MRB (QSI042) Approval	Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
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Root Cause <table border="0" style="width: 100%;"> <tr> <td style="width: 50%;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width: 50%;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>		Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	FAULT CATEGORY <table border="0" style="width: 100%;"> <tr> <td style="width: 33%;"> Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width: 33%;"> Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> <td style="width: 33%;"> Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ </td> <td style="width: 33%;"> Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐ </td> </tr> </table>				Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																														
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OTHER : _____																																									



B67-43001-173F FLAT PATTERN



B67-43001-173B BENDING DETAIL
(MAKE FROM B67-43001-173F)



NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.032 THICK
PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF. DART SPEC. M2024T3S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "B67-43001-173B" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.48 lbs

DESIGN	RW	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		B67-43001-173	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.	N/A	COVER PLATE	NTS
DATE	14.07.14	COPYRIGHT © 1995 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

RELEASED
2014-12-08

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Skid-tube ☐ Cross tube ☐ Water Jet ☐ Engineering ☐ Scrap ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Quality ☐ Use-as-is ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐					
Date :		Step #:		QTY Effective :		MRB (QSI042) Approval			
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

PROPERTY INFORMATION COMPANY

Incident Date: 1967-03-01	Incident Time: 13:45	Incident Location: 134673
Incident Description: 134673	Incident Type: 134673	Incident Status: 134673
Incident Cause: 134673	Incident Effect: 134673	Incident Impact: 134673
Incident Action: 134673	Incident Result: 134673	Incident Conclusion: 134673



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO11110

Purchase Order Date 1/22/2016

PO Print Date 1/28/2016

Page Number 3 of 4

Order From :

VC-TUL001

Ship To : DART AEROSPACE LTD

TULMAR SAFETY SYSTEMS
1123 CAMERON ST
HAWKESBURY, ON K6A 2B8
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

613 632 1282

Ship To Contact

Ship To Phone

Ship Via:

VENDOR'S TRUCK

Ship Acct:

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

CAD

FCA - (Free Carrier)

Line Total:

\$2,400.00

6 138694

PB67-43001-181 COVER
PLATE

2/19/2016

15.00

\$ 30.00

\$1,950.00

Yes

2/19/2016

FOAM AND FABRIC AS PER DWG PD67-43001-181 REV. D
TULMAR P/N: 8421-103

Line Total:

\$1,950.00

7 138693

PB67-43001-173 COVER
PLATE

2/19/2016

16.00

\$ 30.00

\$2,080.00

Yes

2/19/2016

FOAM AND FABRIC AS PER DWG PD67-43001-173 REV. D
TULMAR P/N: 8421-104

Line Total:

\$2,080.00

PO Instructions: SALES QUOTE NO. 16014,16058

Note:

1/28/2016

PACKING SLIP

TULMAR

Tulmar Safety Systems Inc.
1123 Cameron Street
Hawkesbury, ON K6A 2B8
Tel: 613-632-1282
Fax: 613-632-2030
GST R132478223
MID : XOTULSAF1123HAW
email: info@tulmar.com

Packing Slip No Page

56789 1

Ship Date
2/23/2016

Bill To:

Dart Aerospace

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship To:

Dart Aerospace

1270 Aberdeen Street
Tel: 613-632-9577
Hawkesbury, ON K6A 1K7
Canada

Order number 33591 Sales order date 1/27/2016 Account number CDART100 Loc H Account manager Francine Bigras

PO number PO311110 Ship via Pick-Up Shipping Terms FOB HAWKESBURY

Item No. Description	Quantity ordered	UOM	Qty Shipped/Returned	Quantity on back order
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QA: A004 A005 A007 A016 A026 A040
A041 A043 (TSS = 5 YRS ONLY)

8421-103 Cover Plate	15.00	EA	15.00	
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Drawing No: B67-43001-181
DWG Rev: D
Item 6

Lot no.: BATCH0000000010 15.00

8421-102 D-Pad Assembly, Long	11.00	EA	11.00	
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Drawing No: B67-43001-85 + MU
DWG Rev: D+1

Lot no.: BATCH0000000010 11.00

8421-101 D-Pad Assembly, Short	54.00	EA	54.00	
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Drawing No: B67-43001-83
DWG Rev: D

Lot no.: BATCH0000000012 54.00

8421-104 Cover Plate	16.00	EA	16.00	
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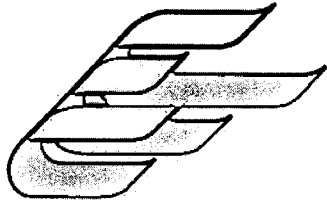
Drawing No: B67-43001-173
DWG Rev: D
Item 7

Lot no.: BATCH0000000011 16.00

8421-105 Cover Plate, 20°	16.00	EA	16.00	
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Drawing No: B67-43001-73+MU
DWG Rev: C+1
Item 2

Lot no.: BATCH0000000009 16.00



J. ENNIS FABRICS

June 10, 2015

Fax To: Tulmar Safety Systems

Fax: 613-632-2030

Attention: Sandra Nadeau

Certificate of Conformance

Re: PO 28594-00 for Oxford 7 black

The goods shipped on P/O 28594-00 are as per sampled goods. Specification as follows:
As per mill documentation:

Oxford 7 black is in compliance with the following standards:

Width: Product is 58 Inches Wide.

Roll Size: Average Roll Length is 75 Yards.

Weight: Product Weight is 6.79 Ounces per Sq.Yd. /Product Weight is 10.94 oz per Lin.Yd

Content: 100% Nylon

Coating: Product has a Polyurethane Coating {approximately 0.65 oz/ Sq.Yd. (18.5g/sq.yd.)}

Denier: Yarn is 420 Denier.

Thread Count: Construction is 62 x 38 Threads per Square Inch

Protective Finish: Product is Water Repellent.

Hydro Resist: AATCC 127 (Suter): Average 800 mm

Piece # 111926200 Manufacture Date: 03/25/15, **Lot Number:** 444815

Sincerely;

J. Ennis Fabrics Ltd.

S, Nolan

Susan Nolan
Customer Service Specialist

JUN 19 2015



1495 # 33
B

C/c's used to mfg:
B67-43001-181 Rev.D
B67-43001-173 Rev.D
B67-43001-73+MU Rev. C+1
B67-43001-69+MU Rev. D+1
B67-43001-33+MU Rev. C+1

Louise Laliberté (QC) Feb. 23/16

TULMAR**Certificate of Conformance**

Tulmar P/N 1637-001	Description Foam, SBR/EPDM/CR blend, black, ASTM D1056 2a2, 1/2" thick, 42"x72", brittle temp of -40°F IAW ASTM D746, FMVSS 302	Dwg # N/A	Revision -	Qty 4
Tulmar PO # 27193-00	Line Item # 1	Supplier Name / Address Am Rubber & Foam Gaskets Inc. 2074 Steeles Ave. East Units 1 & 2, Brampton On L6L 4Z9	Supplier Packing Slip # 12190	

Supplier Declarations:

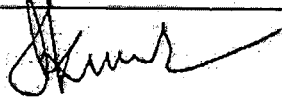
Hazardous Materials Acknowledgement	The items described below may contain, and their processing may have included, the following substances:	Hexavalent Chromium; Cadmium; Beryllium; Nickel; Mercury; Lead; Asbestos; Radioactive elements YES ☐ NO ☒
Country of Origin of Goods : CANADA		if YES, please complete the HazMat Acknowledgement form @ www.tulmar.com
Limited Shelf-Life	<u>Definition:</u> If material is consumed or transformed into final product before end of shelf-life there is no effect on final product.	These items have a limited Shelf-Life YES ☐ NO ☒
Expiry date	<u>Definition:</u> Date after which performance will no longer be as intended - expiration is transferred to the final product.	These items have an expiry date YES ☐ NO ☒

if YES, please complete the Time Expired - Shelf-Life questionnaire @ www.tulmar.com

Additional Information (MRS#, MRA#, limitations, etc...):

--

I hereby certify that the goods listed hereon have been inspected and/or tested, as applicable, and conform to all specifications and requirements detailed in the contract or purchase order and relevant quality clauses. Objective evidence to support this statement is on file and can be made available upon request. Should further information be required, please contact:

Signature 	Name Joseph Mallek	Date (DD-MMM-YYYY) 02/01/2014
Title QA MANAGER	Email Joe.Mallek@amrubber.ca	Phone # 647-5011449

Form Revision 13 Aug 2012

TSS # 1637-001/05

50

TULMAR**Certificate of Conformance**

Tulmar P/N 2530	Description Thread, Nylon, Black, A-A-59826, FY7, C/LA, Size F, Quality Class: Grd, Country of Origin USA M3 C0002	Dwg #	Revision	Qty 40 Spl
Tulmar PO # 27000-00	Line Item # 1	Supplier Name / Address CANSEW INC, 111 Chabanel West, Suite 101, Montreal, Que., H2N 1C9	Supplier Packing Slip # H66082	

Supplier Declarations:

Hazardous Materials Acknowledgement	The items described below may contain, and their processing may have included, the following substances:	Hexavalent Chromium; Cadmium; Beryllium; Nickel; Mercury; Lead; Asbestos; Radioactive elements YES ☐ NO ☒
Country of Origin of Goods : USA		if YES, please complete the HazMat Acknowledgement form @ www.tulmar.com
Limited Shelf-Life	<u>Definition:</u> If material is consumed or transformed into final product before end of shelf-life there is no effect on final product.	These items have a limited Shelf-Life YES ☐ NO ☒
Expiry date	<u>Definition:</u> Date after which performance will no longer be as intended - expiration is transferred to the final product.	These items have an expiry date YES ☐ NO ☒

if YES, please complete the Time Expired - Shelf-Life questionnaire @ www.tulmar.com

Additional Information (MRS#, MRA#, limitations, etc...):

--

I hereby certify that the goods listed hereon have been inspected and/or tested, as applicable, and conform to all specifications and requirements detailed in the contract or purchase order and relevant quality clauses. Objective evidence to support this statement is on file and can be made available upon request. Should further information be required, please contact:

Signature 	Name Hershie Schachter	Date (DD-MMM-YYYY) 28-Jan-2014
Title President	Email hershie@cansew.ca	Phone # (514) 382-2807

Form Revision 13 Aug 2012

2530/53 (SN)



48 Burgess Place
Wayne, NJ 07470

Certificate Of Analysis

11/11/2015

Sales Order Number: 5927
Customer Order Number: 29283

Manufactured for
TULMAR SAFETY SYSTEMS

14172-C6.9A LA4009NOVOC, P/N 7122-001 14172-C6.9A - LA4009NOVOC, UNLINED GALLON CAN

Lot# PNJ-1015-0252 Qty: 52 EA Manufacture Date: 11/4/15 Expiration Date: 11/4/16

Test(s)	Results	Min	Max	
% Solids @275F for 30 minutes	14.3000	13.00	15.00	Percent
Brookfield, RVT, #3 Spindle, 20RPM, 78F	1,150.0000	800.00	1,500.00	Centipoise
Visual check for dry film color	pass	(CLEAR TO HAZY YELLOW) PASS/FAIL		

"The material supplied conforms to all applicable engineering drawing, specifications and PO requirements."

Dan Constantino
Daniel Constantino
Quality Assurance Mgr/ISO Coordinator
Country of Origin: USA



7122-001 B#5